

Work Order ID 138931

138931

Page 1

Friday, November 13, 2015 11:36:31 AM

Item ID: D5189-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube Assembly
 Start Date: 11/13/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: NOV 16 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5189	A								

100 0.00
100 Large Fab
 Large Fab Memo 0.02
 Large Fab 1-Cut tube as per Dwg D5189
 2-Drill tube as per Dwg D5189 using DT8622
 3-Deburr
 4-Weld stud and end cap as per Dwg D3021 QSI004
 A/R 4130 Rod Batch: 1127825

1 EL 1578-21

110 0.00
110 QC9- Inspect visual per QSI004- Fusion Welds
 QC Memo 0.00
 Quality Control

2 15-12-22 **DAS**
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120									
QC	Memo	0.00							
Quality Control									
130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							DAS 34 9-89
130	<i>m 130746</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>8:45</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>9:15</i>								
140	QC3- Inspect Part Finish	0.00							DAS 9 9-89
140									
QC	Memo	0.00							
Quality Control									

① 15-12-22

1 15-12-22 DAS 34 9-89

① DEC 23 2015 DAS 9 9-89

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150	Identify as per dwg & Stock Location: <i>SA</i>	0.00			/				
150									
Packaging	Memo	0.00							
Packaging									
						DEC 23 2015			DAS 6 8-89
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 5-12-23

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Picklist Print

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Parent Item: D5189-041

D5189-041

Parent Item Name: Tube Assembly

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.11.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3017-11		Manufactured	No				Each	21.0000		1			
D3017-11									**			<u>EL 15-12-21</u>	
Cap													

Location	Loc Qty	Loc Code
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WA001	21	
<u>134300</u>	21	

D4667-041		Manufactured	No				Each	4.0000		1			
D4667-041									**			<u>EL 15-12-21</u>	
Armrest Stud Assembly													

Location	Loc Qty	Loc Code
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WA002	4	
<u>134537</u>	4	

M4130NT0.750W.049		Purchased	No				f	70.1000		2.244211			
M4130NT0 750W 049									**			<u>EL 15-12-21</u>	
4130 RD Tube .750 x.049W													

Location	Loc Qty	Loc Code
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MAT	27.2	
<u>m133083</u>	20	
m133307	7.2	
MAT033	42.9	
m122425	22.5	
m131541	20.4	

DQA: _____ Date: _____



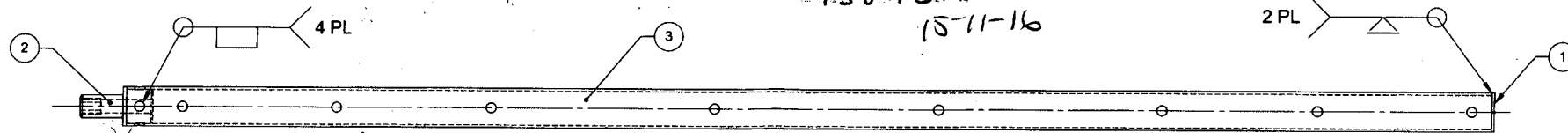
WORK ORDER NON-CONFORMANCE / UPDATE

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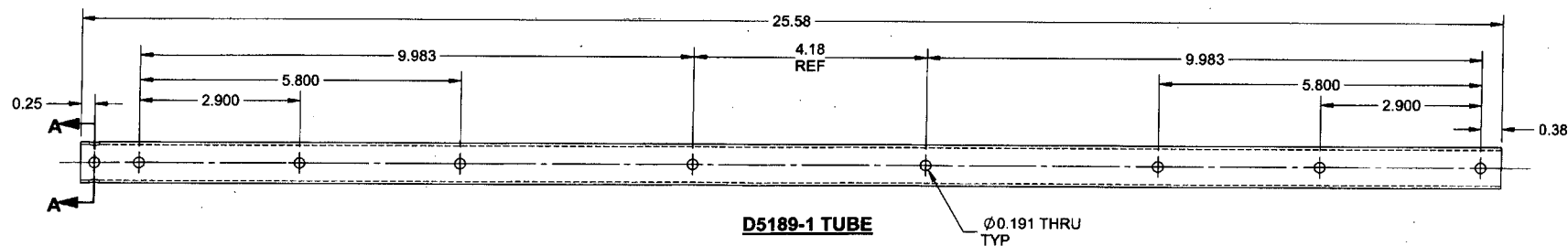
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																		
Large Fab ☐	Composite ☐	Supplier ☐																																																																			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																														
Description Work Order Deviation				Disposition			Completed By																																																														
Root Cause				FAULT CATEGORY																																																																	
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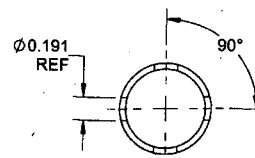
ITEM	QTY	P/N	DESCRIPTION
	X	D5189-041	TUBE ASSEMBLY
1	1	D3017-11	END CAP
2	1	D4667-041	ARMREST STUD ASSY
3	1	D5189-1	TUBE



D5189-041 TUBE ASSEMBLY



D5189-1 TUBE



SECTION A-A
SCALE 2X

NOTES:

- 1) MATERIAL -041: N/A
-1: AISI 4130N SEAMLESS STEEL TUBING, Ø0.750 X 0.049 WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF M4130NT0.750W0.049
- 2) FINISH -041: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.85 lbs
- 8) WELD PER DART QSI 004

RELEASED

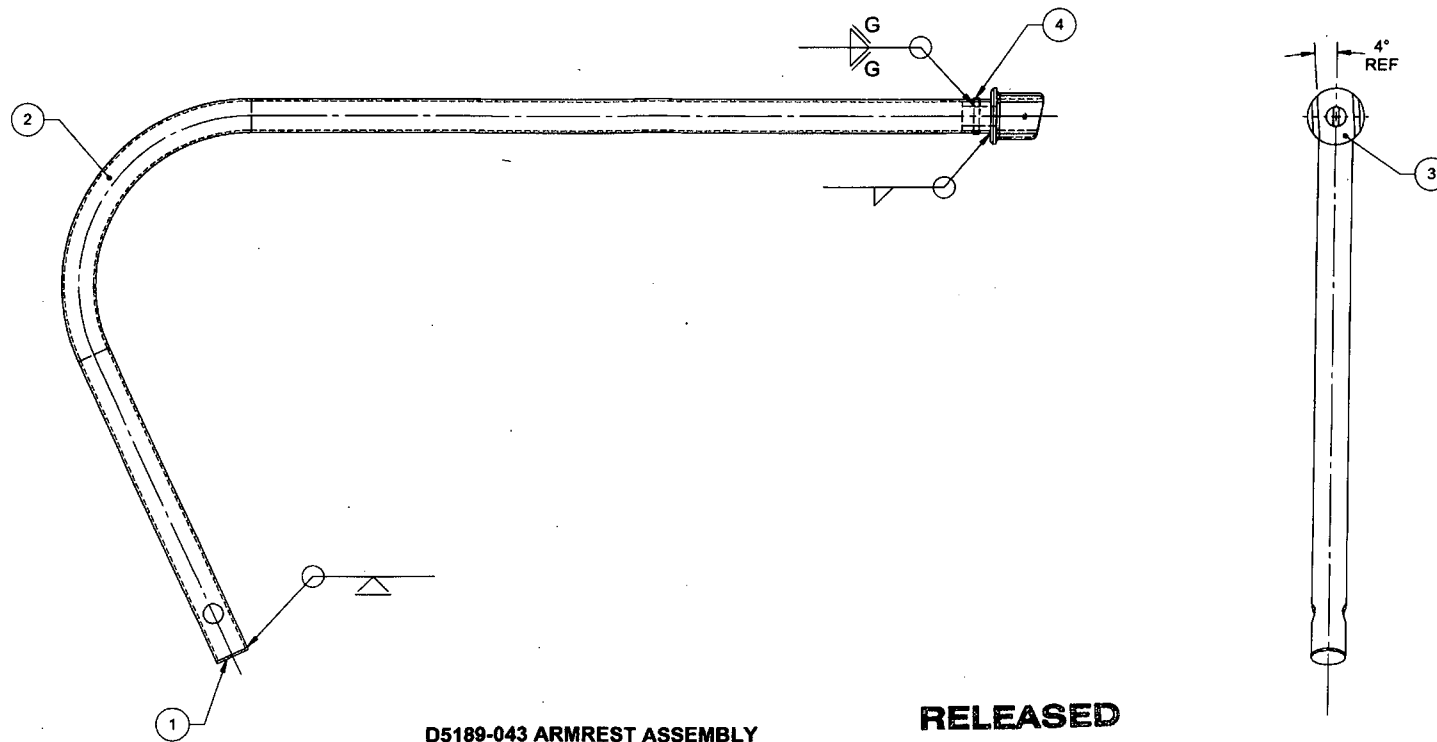
2015 FEB 04

ECN 15-522 d

A NEW ISSUE		AJS	14.11.18
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5189	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARMREST COMPONENTS	NTS
DATE	14.11.18	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5189-043	ARMREST ASSEMBLY
1	1	D3017-11	END CAP
2	1	D5189-3	ARMREST
3	1	D5190-1	ARMREST FITTING
4	1	D5190-3	WELD PIN



D5189-043 ARMREST ASSEMBLY

RELEASED

2015 FEB 04

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.08 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5189	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
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